

Ship May 19

Work Order ID 132844

132844

Page 1

Monday, May 11, 2015 3:57:31 PM

Item ID: D4889-041L02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dome Light Air Vent Assembly, Black

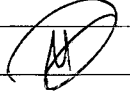
Start Date: 5/11/15 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/18/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan:  Date: 5.5.11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4889	A

100		0.00							DAS 07 9-89
100						x 2			15/05/14
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								

110		0.00							DAS 07 9-89
110						x 2			15/05/14
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D4889-041								

- 1) Install air vents
- 2) Install lights
- 3) Install rheostats
- 4) Install wiring harness

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Page 2

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N900040100

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Revision ID:

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Cust Item ID:

Required Date: 5/18/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

MAY 19 2015

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

MF shipped

SO 121432

DAB
27
9-88

5102 S1 XW

MAY 19 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MAY 19 2015

MUS

ME
15-5-19

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

Monday, May 11, 2015 3:57:36 PM

Page 1

Work Order ID: 132844

132844

Parent Item: D4889-041L02

D4889-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 5/11/15

Required Date: 5/18/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 13/09/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1		Manufactured	No			100	Each	6.0000	2	4			DAS 07 9-89

D4886-1

Air Vent

Location Loc Qty Loc Code

ST137

2

118874

2

ST142b

4

125759

4

D4889-1L02

Manufactured

No

100

Each

0.0000

1

2

**DAS
07
9-89**

D4889-1L02

Dome Light Housing, Black

D4897-041

Manufactured

No

100

Each

8.0000

1

2

**DAS
07
9-89**

D4897-041

Dome Light Wiring

Location

Loc Qty

Loc Code

MF

8

128025

8

D4898-1

Manufactured

No

100

Each

134.0000

12

24

**DAS
07
9-89**

D4898-1

Screw, Stainless Steel

Location

Loc Qty

Loc Code

MF

34

107709

16

113458

18

ST137

100

127703

100

DQA: _____ Date: _____



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Page 2

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D4889-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 5/11/15

Required Date: 5/18/15

Start Qty: 2.00

Required Qty: 2.00

D4906-1 Manufactured No

100 Each 19.0000 1 2

DAS
07
9-89

D4906-1

Knob

**

15/05/14

Location

Loc Qty

Loc Code

MF

19

107708

9

128364

10

2

MS21042L06

Purchased No

100 Each 346.0000 12 24

DAS
07
9-89

MS21042L06

Nut

**

15/05/14

Location

Loc Qty

Loc Code

ST260a

300

m131317

300

ST304

37

m131294

37

ST305

9

m129499

9

18

6

6

NAS1149F0663P

Purchased No

100 Each 133.0000 3 6

DAS
07
9-89

NAS1149F0663P

WASHER

**

15/05/14

Location

Loc Qty

Loc Code

st268

133

M128591

2

M131317

131

6

NAS1149FN632P

Purchased No

100 Each 251.0000 12 24

DAS
07
9-89

NAS1149FN632P

Washer

**

15/05/14

Location

Loc Qty

Loc Code

st268

251

m129163

251

24

Monday, May 11, 2015 3:57:36 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



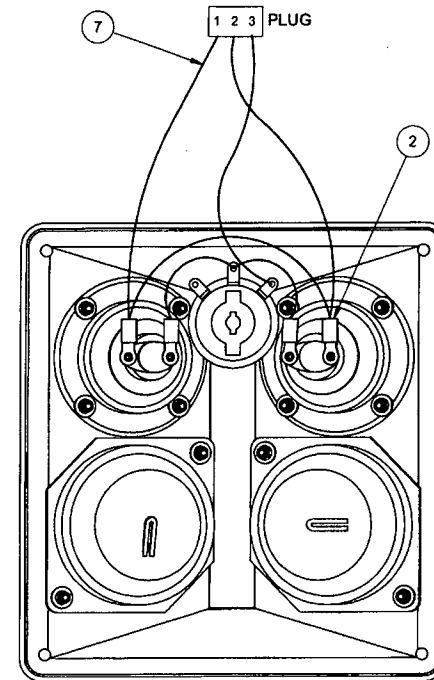
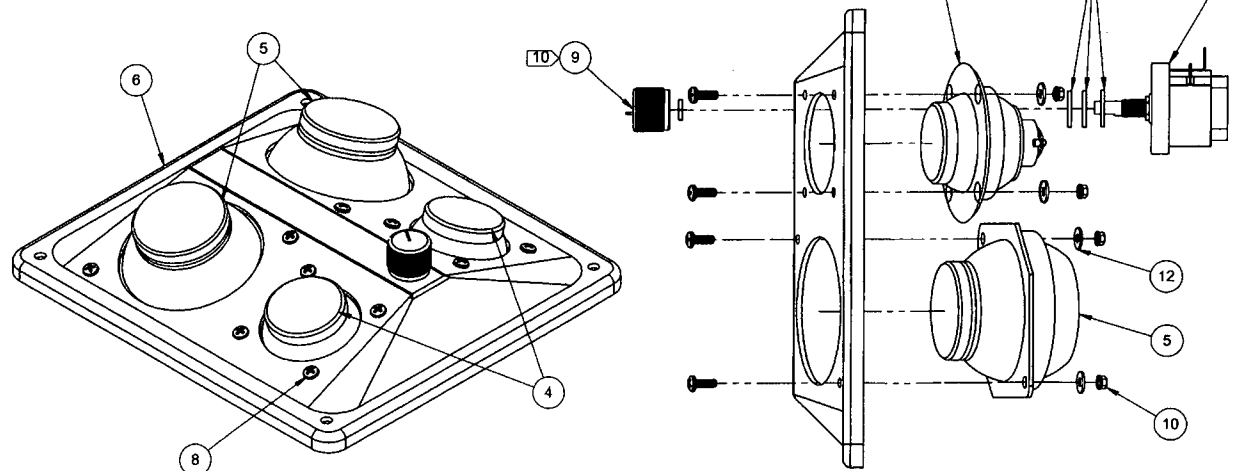
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4889-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4889-1	DOMELIGHT HOUSING
7	1	D4897-041	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER



D4889-041 DOMELIGHT AIR VENT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.41 lbs
- 8) REPLACES GENEVA P/N GA129-11 P112-S
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

Handwritten: 155-7
132844

RELEASED
2013-09-16

A	NEW ISSUE	13.07.11
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	13.07.11	

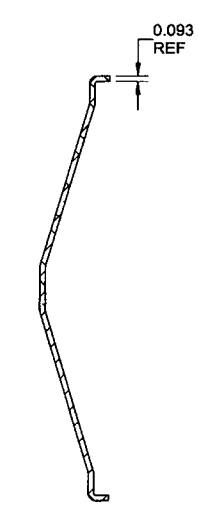
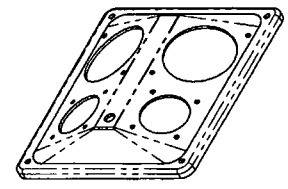
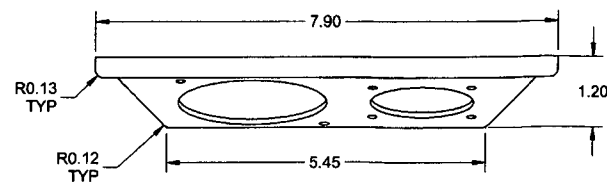
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4889** REV. A
SHEET 1 OF 3

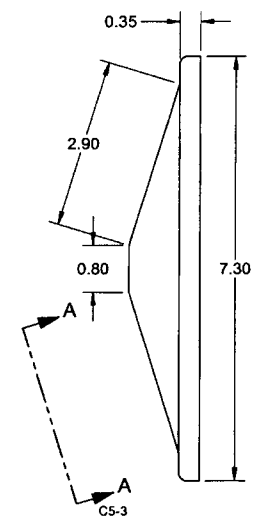
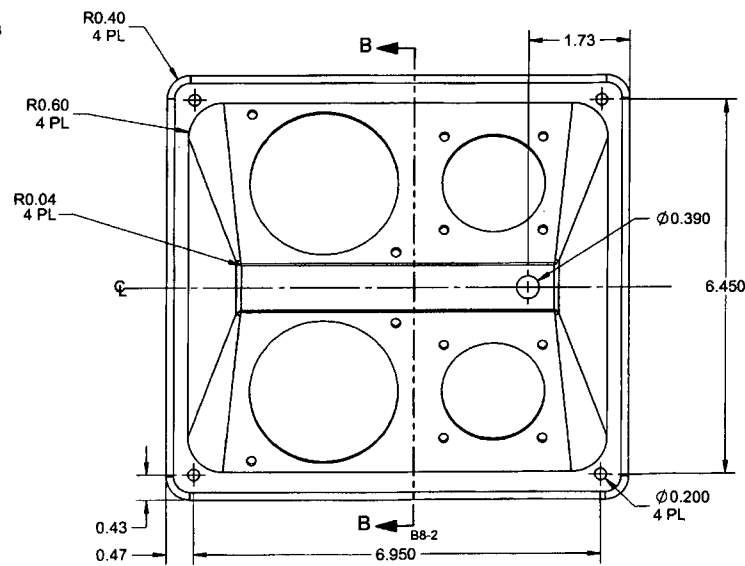
TITLE **DOMELIGHT AIR VENT ASSY** NTS
SCALE

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8 7 6 5 4 3 2 1



SECTION B-B
B6-2



- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) TOOLING: THERMOFORM PER MOLD DT9934 PER QSI 022 TRIM PER DT9934
 - 3) FINISH: N/A
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: 0.21 lbs
 - 9) REPLACES GENEVA P/N GA129-6
 - 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
 - 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

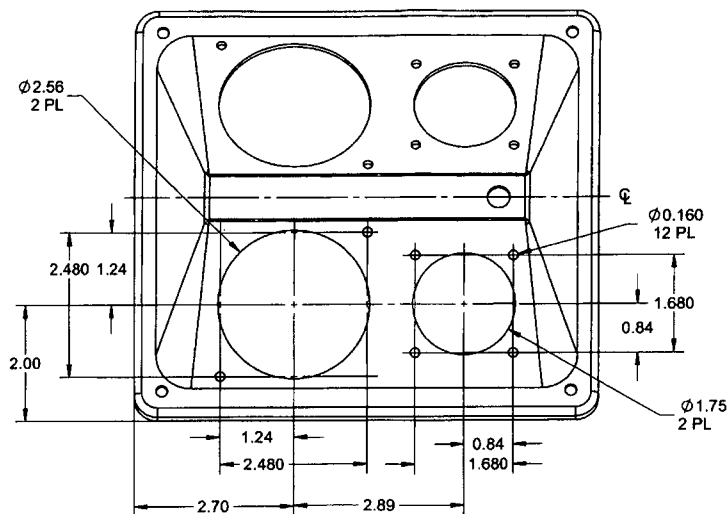
D4889-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4889-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4889-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.07.11

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4889	REV. A SHEET 2 OF 3
TITLE DOME LIGHT AIR VENT ASSY	SCALE NTS
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RELEASED
2013-09-16
MD



VIEW A-A

B3-2

RELEASED
2013-09-16
mt

DESIGN	<i>OS</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>OS</i>	KENT, WA	
CHECKED	<i>DZ</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>HE</i>	D4889	SHEET 3 OF 3
APPROVED	<i>HE</i>	TITLE	SCALE
DE APPR.	<i>HE</i>	DOMELIGHT AIR VENT ASSY	NTS
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